



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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C3-18-1

Job Sheet 181865



Part No: C3-18-1

Job Qty: 10 ea

Part Name: Lifting Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/10/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C3-18-1 Rev 4 IPP Rev A 18.04.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	10 Ea		9/21/18	0.00	0.00	Start Up Waterjet2		18/08/14
110	Waterjet	10 pcs		9/21/18	0.00	1.00	Waterjet 2 OMAX		18/08/14
120	QC	10 pcs		9/21/18	0.00	0.00	QC2 Waterjet-2		18/08/14
130	QC	10 pcs		9/21/18	0.00	0.00	QC8-6		SEP 04 2010 DAS 68
140	Packaging	10 pcs		9/21/18	0.00	0.00	Packaging3		9-89
150	QC21-SA	10 Ea		9/21/18	0.00	0.00	QC21		18.09.06

Part Op 100 -

Descriptions: 110 - 1-Cut as per Dwg Dwg Rev: 4 Prog Rev: 4 2-Deburr if necessary

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NS.188	4130 Sheet .188	2.6600 sf (.266 ea)	100-Start up Operation	5078/50

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	M4130NS.188	3	7	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description \	DISPOSITION Rework ☐ Scrap ☐ _____ ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
		MRB (QSI042) Approval			
		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			

Dart Aerospace Ltd.
 1270 Aberdeen Street
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 CANADA
 TEL.: 1 613 632 - 6200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 08/14/18

Container No: S102095
Part: C3 - 18 - 1
Job No: 181865
Serial No/Batch: S102095
 Revision: 4
 Inspector:
 Exp Date:
 Instructions:

Root Cause

Environment	☐	No Re-ver	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Centre Not Concentric
 Cracks
 Crimp/Kink/Ripple/Wave
 Cuffs
 Crushing
 Heat Treat
 Wave/Twist in Tube
 Marks/Chatter

Broken/Damage/Defect
 Inspection Incomplete/Unqualified
 Contamination
 Countersink
 Cut Too Short
 Instructions Incomplete/Unclear
 Drill Holes

Weir
 Wrong Stock Pulled
 Out of Sequence
 Off-set
 Mislabeled
 Fit/Function
 Misaligned/off center

/Surge
 ram
 Positioned Wrong
 Outside Dimensions
 Over/Under tolerance
 Part Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

OTHER :

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

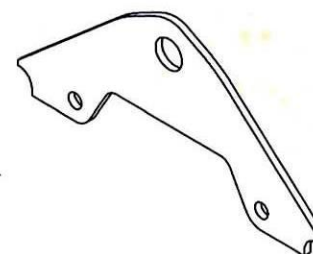
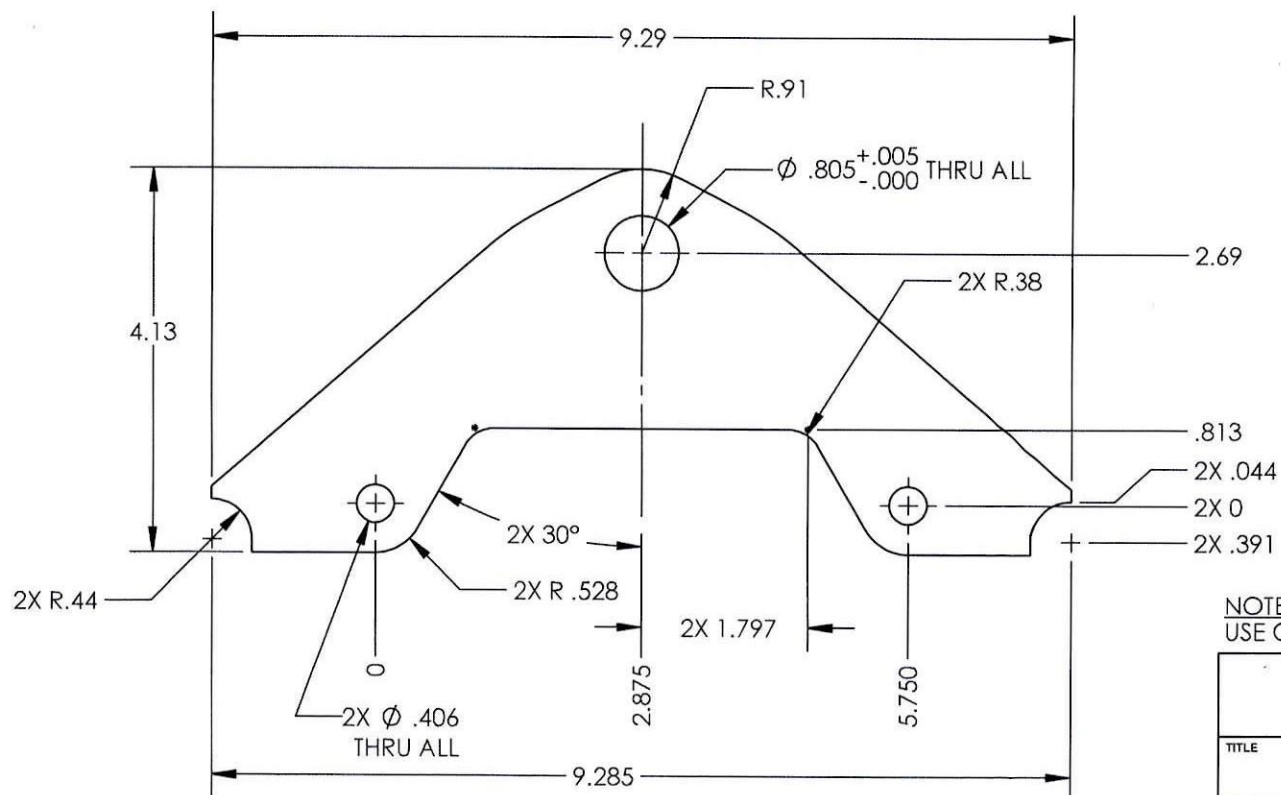


QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVE
2		AS DRAWN PER CANAM	8/8/2012		
3	16-0229	UPDATED TO NEW STANDARD. CH'D MAT'L FROM A36 P&O TO 1018/1020 CR. CH'D DIMS WAS 2X Ø.386 THRU ALL IS 2X Ø.406 THRU ALL, WAS 9.291 IS 9.29, WAS 2.692 IS 2.69, WAS 4.125 IS 4.13, WAS (1.188) IS .19, WAS 2X R.375 IS 2X R.38, WAS 2X R.435 IS 2X R.44, DELETED DIMS R3.000, 1.773, 1.768, 8.415, 2X .176, 2X .528, ADDED USE CAD DATA NOTE, CH'D DWG TO SHEET METAL TOLERANCE.	11/21/2016	DPD	JAG
4	17-0175	CH'D MAT'L WAS 1018/1020 CR IS A514.	7/17/2017	RJC	JAG



NOTE:
USE CAD DATA

			
TITLE			
LIFTING PLATE			
DWG NO.			REV
C3-18-1			4
MAT'L A514		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
		.X ± .1 SURFACES = 125/√	
DRAWN BY: CANAM		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT			
SCALE	1:2	DATE	11/30/2001
		SHEET 1 OF 1	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					